

Date: Wednesday, 22/10/2008 11:26:24 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHOULDER HARNESS KIT
Job Number	: 42800		
Estimate Number	: 13048		
P.O. Number	:	Part Number	: D350764011
This Issue	: 22/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: 11	Project Number	: N/A
Previous Run	: 42130	Drawing Revision	: B
Written By	:	Material	:
Checked & Approved By	: <u>JUD 08.10.22</u>	Due Date	: 30/10/2008
Comment	: EST REV:A New issue 07-10-11 DD verified by EC Est Rev:B ECN 1050 rev.B as per dwg 08-01-10 DD		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-764-011 CHG001

8 08/10/28

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

3.0	D2854	3/4" Velcro Strip
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Comment: Qty.: 2.6660 f(s)/Unit Total: 2.6660 f(s)

3/4" Velcro

Cut qty 4 D2854-1-080 (8" each) as per dwg D2854

Batch: B40089

4.0	D2854	3/4" Velcro Strip
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Comment: Qty.: 2.6660 f(s)/Unit Total: 2.6660 f(s)

3/4" Velcro

Cut qty 4 D2854-3-080 (8" each) as per dwg D2854

Batch: B40089

5.0	D3578041	Doubler
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Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

DOUBLER

batch B3937

B42300

8/10/23

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 42800

Part Number: D350764011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D3636041	Shoulder Harness
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

SHOULDER HARNESS

batch B42133

SP

7.0	D3637041	Bracket Assembly
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BRACKET ASSEMBLY

batch B351310

42822

8/10/22

SP

8.0	D36373	Bracket
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BRACKET

batch B35389

SP

9.0	D36381	Bushing
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BUSHING

batch B35388

SP

10.0	D36391	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

DOUBLER

batch B35128

SP

11.0	D36392	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

DOUBLER

batch B34539

SP

12.0	D36393	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

DOUBLER

batch B35382

8/10/23

(1x)

SP

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13.0	D36394	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DOUBLER
batch B35383

scf

14.0	D36401	Belt Guide
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
BELT GIUDE
batch B42131

scf

15.0	D36403	Belt Guide
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
BELT GIUDE
batch B42132

scf

16.0	D36411	Cover
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
COVER
batch B34542 ①

~~42298~~

~~B~~ 42298 1X / 29/10/08

scf

17.0	D36413	Cover
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
COVER
batch B34543

scf

18.0	D36414	Cover
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
COVER
batch B34544

scf

19.0	D36421	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
DOUBLER
batch B36109

8/10/08

(12)

scf

W/O:		WORK ORDER CHANGES					
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Part Number: D350764011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	D36431	Stiffener
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
STIFFENER
batch 1334547

SP

21.0	D36432	Stiffener
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
STIFFENER
batch 1334548

SP

22.0	D36441	Shim
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SHIM
batch 1334549

SP

23.0	D36571	Guide Tool
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GUIDE TOOL
batch 1334550

SP

24.0	ALS41032130	Insert
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Insert
batch M105819

SP

25.0	AN33A	Bolt
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Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)
Bolt
batch M109632

SP

26.0	AN36A	Bolt
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Bolt
batch M107759

8/10/23

SP

W/O:		WORK ORDER CHANGES					
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Seq. #:	Machine Or Operation:	Description :
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27.0	AN410A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch

M101291

M104603

SP

28.0	AN960JD10	Washer
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Comment: Qty.: 48.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

batch

M109059

SP

29.0	AN960JD416	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M108827

SP

30.0	AN960JD616	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M108521

SP

31.0	AN9706	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M1053821

SP

32.0	CCR264SS33	Cherry Rivet
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Cherry Rivet

batch

M109405

SP

33.0	CR321242	Cherry Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cherry Rivet

batch

M107394

8/10/23

SP

W/O:		WORK ORDER CHANGES					
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Job Number:



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34.0	CR3212504	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch M106321

SP

35.0	CR3212507	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch M105978

SP

36.0	MS20426AD33	Rivet
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Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Rivet

batch M1363

SP

37.0	MS20426AD44	Rivet
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Comment: Qty.: 106.0000 Each(s)/Unit Total : 106.0000 Each(s)

Rivet

batch M1021

M105541

SP

38.0	MS20426AD46	Rivet
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Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Rivet

batch M105144

SP

39.0	MS20470AD46	Rivet, Universal Head
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet, Universal Head

batch M108377

SP

40.0	MS21059L3	Nut Plate
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut Plate

batch M107479

8/10/23

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Seq. #:	Machine Or Operation:	Description :
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41.0	MS21072L3	Nutplate
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Nutplate
batch M107003

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42.0	MS35206267	Screw
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Screw
batch M109389

8/10/23

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43.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

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44.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-764-011
Location: 51
PPP Rev: B

8/10/28

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45.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

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Job Completion



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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